



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

647.7611

Job Sheet 181390-A



*Split From
181390*

Part No: 647.7611

Job Qty: 25 ea

Part Name: Lower Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 12/4/18

Job Tracking No:

Due Date: 9/10/18

Created By: Natasha Belanger

Type: Stock

Description:

Note: DWG REV N/C SHEETS 1,3 IPP REV: A NEW ISSUE 15/08/05 JFS VERIFIED BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
130	QC	25 pcs		9/10/18	0.00	0.00	QC8 Machining-1		<i>See Pages 5 in back</i> DEC 04 2018 DEC 11 2018 DEC 11 2018
140	Outsource	25 pcs		9/10/18			ATG001-VC	5	
150	Packaging	25 pcs		9/10/18	0.00	0.00	Packaging2		
155	QC	25 pcs		9/10/18	0.00	0.00	QC5		
180	Packaging	25 pcs		9/10/18	0.00	0.00	Packaging3-1		
190	QC21-SA	25 Ea		9/10/18	0.00	0.00	QC21		

Part Op 140 - Issue P/O to ATG : _____ Hard Black Anodize and Prime as per Dwg 647.7600
Descriptions: 180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Job BOM records could not be found.

Job Allocations

Job Allocations could not be found.

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Deflector	0.125inches + 0.010 - 0.000	0.135 0.000		
2	Lower Deflector	45.000Degrees ± 0.500	45.500 44.500	Angle	
3	Lower Deflector	0.177inches + 0.005 - 0.001	0.182 0.176	Diameter	
4	Lower Deflector	0.188inches + 0.005 - 0.001	0.193 0.187	Diameter	
5	Lower Deflector	0.201inches + 0.005 - 0.001	0.206 0.200	Diameter	
6	Lower Deflector	0.488inches ± 0.010	0.498 0.478		
7	Lower Deflector	1.000inches ± 0.010	1.010 0.990		



Container No: S134339



Part: 647.7611

Job No: 181390 - A

Serial No/Batch: S115084

Revision:

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.

1270 Aberdeen Street

Hawkesbury, ON K6A 1K7

CANADA

TEL.: 1 813 632-5200

Email: sales@dartaero.com

www.dartaerospace.com

Date: 12/04/18

8	Lower Deflector	5.970inches $\pm$ 0.010	5.980 5.960	
9	Lower Deflector	10.433inches $\pm$ 0.010	10.443 10.423	
10	Lower Deflector	11.075inches $\pm$ 0.010	11.085 11.065	
11	Lower Deflector	11.449inches $\pm$ 0.010	11.459 11.439	
12	Lower Deflector	11.569inches $\pm$ 0.010	11.579 11.559	
13	Lower Deflector	10.213inches $\pm$ 0.010	10.223 10.203	
14	Lower Deflector	7.289inches $\pm$ 0.010	7.299 7.279	
15	Lower Deflector	5.985inches $\pm$ 0.010	5.995 5.975	
16	Lower Deflector	3.785inches $\pm$ 0.010	3.795 3.775	
17	Lower Deflector	1.585inches $\pm$ 0.010	1.595 1.575	
18	Lower Deflector	0.375inches $\pm$ 0.010	0.385 0.365	
19	Lower Deflector	0.376inches + 0.002 - 0.000	0.378 0.376	
20	Lower Deflector	0.560inches $\pm$ 0.010	0.570 0.550	
21	Lower Deflector	0.920inches $\pm$ 0.010	0.930 0.910	
22	Lower Deflector	0.250inches $\pm$ 0.010	0.260 0.240	Radius

Plex 12/4/18 9:13 AM dart.belanger.natasha



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647.7611

Job Sheet 181390



Part No: 647.7611

Job Qty: 50 ea

Part Name: Lower Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 7/26/18

Job Tracking No:

Due Date: 9/10/18

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV N/C SHEETS 1,3 IPP REV: A NEW ISSUE 15/08/05 JFS VERIFIED BY: JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	50 Ea		9/10/18	0.00	0.00	Start Up Machining-1		
100	Bandsaw	50 pcs		9/10/18	0.00	2.25	Bandsaw1		
110	CNC Vertical Machining	50 pcs		9/10/18	0.51	75.41	HAAS1-1		
120	QC	50 pcs		9/10/18	0.00	0.00	QC1		
130	QC	50 pcs		9/10/18	0.00	0.00	QC8 Machining-1		
140	Outsource	50 pcs		9/10/18			ATG001-VC	5	
150	Packaging	50 pcs		9/10/18	0.00	0.00	Packaging2		
155	QC	50 pcs		9/10/18	0.00	0.00	QC5		
180	Packaging	50 pcs		9/10/18	0.00	0.00	Packaging3-1		
190	QC21-SA	50 Ea		9/10/18	0.00	0.00	QC21		

Part Op 100 - Cut Blank at 16.800"

Descriptions: 110 - 1-Machine per folio FB406

120 - Inspect on CMM as per folio CMM010.

140 - Issue P/O to ATG : _____ Hard Black Anodize and Prime as per Dwg 647.7600

180 - ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING P# AND REV***

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M7075T6B6.000X1.000	7075-T6 Bar 6.000" X 1.000"	70 ft (1.4 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	M7075T6B6.000X1.000	70	0	0

Part Specifications

Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Lower Deflector	0.125inches	+ 0.010 - 0.000	0.135 0.000	
2	Lower Deflector	45.000Degrees	± 0.500	45.500 44.500	Angle
3	Lower Deflector	0.177inches	+ 0.005 - 0.001	0.182 0.176	Diameter

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐
OTHER :					

4	Lower Deflector	0.188inches + 0.005 - 0.001	0.193 0.187	Diameter
5	Lower Deflector	0.201inches + 0.005 - 0.001	0.206 0.200	Diameter
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Plex 7/26/18 8:00 AM Dart.lajeunesse.marie

DART
AEROSPACE

Container No: S134339

Part: 647.7611

Job No: 181390

Serial No/Batch: S115084

Revision:
Inspector:
Exp Date:
Instructions:

Date: 12/04/18

DART
AEROSPACE

Container No: S115084

Part: 647.7611

Job No: 181390

Serial No/Batch: S115084

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Inspector:
Exp Date:
Instructions:

Date: 10/01/18

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DQA:

Date:

WORK ORDER NON-CONFORMANCE / UPDATE



QA Closed:

Date:

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width:100%; border: none;"> <tr> <td style="width:15%;">Skid-tube ☐</td> <td style="width:15%;">Cross tube ☐</td> <td style="width:15%;">Water Jet ☐</td> <td style="width:15%;">Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																																															
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Tel (613) 632-5200

PURCHASE ORDER **PO041274**

Supplier: ATG001-VC
A.T.G. Industries Inc
731 INDUSTRIELLE ROAD
ROCKLAND
ON
K4K 1T2 Canada
Phone: 613-446-4544
Fax: 613-446-4556

PO No: PO041274
PO Date: 10/9/18
Due Date: 11/30/18
Purchase Order
Revision:
Revision Date:
Ship-To Contact: Tsimiklis, ChrisoulaPhone:

Attention: Lalande, Marc-Andre

Via: Ground
Pymt Terms: Net 30

Ship To: 1270 Aberdeen Street
Hawkesbury
ON
K6A 1K7 Canada
Phone: 613-632-5200

Freight Terms:
Special Comments:

Items

Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
1	183919	647.7611	Lower Deflector Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7600	Firmed	-	11/25/18	4 pcs	0 pcs	4 pcs	\$14.59/pcs	\$58.36
	181390	-A Qty 25		Firmed	-	11/25/18	46 pcs	0 pcs	46 pcs	\$14.59/pcs	\$671.14
Sub Total:							50	0	50	50	\$729.50
2 remaining 181390											
2	181394	647.7810	Bracket A Issue P/O to ATG : Hard Black Anodize and Prime as per Dwg 647.7800 Rev. A	Firmed	-	11/25/18	40 pcs	0 pcs	40 pcs	\$17.04/pcs	\$681.60
3	175868	RBW6205G09132-3G-1	Base -Issue P/O to ATG: -ANODIZE COLOR CLEAR, PER-IAW MIL-A-8625F TYPE 2 CLASS 1, Water sealant -Certificate of Conformity is required	Firmed	-	11/25/18	6 pcs	0 pcs	6 pcs	\$42.54/pcs	\$255.24



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PURCHASE ORDER **PO041274**

Items											
Line Item	Job	Part	Description	Status	Account	Due Date	Order Quantity	Received Quantity	Balance	Unit Price (CAD)	Extended Price
4	178661	RBW6205G09132-3G-3	Block -Issue P/O to ATG: ANODIZE COLOR CLEAR, PER IAW MIL-A-8625F TYPE 2 CLASS 1 WATER SEAL -Certificate of Conformity is required	Firmed	-	11/25/18	9 pcs	0 pcs	9 pcs	\$14.54/pcs	\$130.86
Grand Total:											\$1,797.20

Order Notes

Procurement Quality Clauses

A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)

A022 Apical Processing
A024 process certifications
A026 certification of material conformance

A041 quality management system
A042 dart notification by supplier
A043 retention of quality documents

A048 counterfeit parts avoidance, detection, mitigation and disposition program

A049 supplier awareness

Terms & Condition of Purchasing(Suppliers) and Procurement Quality Clauses are an integral part of our AS9100 requirements. To learn in detail, please visit www.dartaerospace.com for further explanation.



A.T.G. Industries Inc.
731 Industrielle Street
Rockland, ON K4K 1T2
Canada

Ph: (613) 446-4544

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Pack List

Number: 916675

Date: 03-Dec-18

To

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ship To

Diane Baker
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury, ON K6A 1K7

Ph: 613 632-9577

Fax: 613 632-1053

Ph: 613 632-9577

Fax: 613 632-1053

Terms		Ship Via	
		ATG Delivery	
Quantity	Description		
	Please reference this document's Pack List number on all correspondences regarding this shipment. If you have any questions, please contact us.		
25 ea	Part: 647.7611 Rev: NC Lower Deflector Hard Black Anodize per MIL-A-8625F, Type III, Class 2, .0005-.0045" (.5 - 4.5mils) Prime per MIL-PRF-23377, Type I, Class N (Customer Supplied), .0001-.0002" (.1 - 2 mils) per drawing. Job: 23948 PO: PO041274 Line: 1		
CERTIFICATE OF CONFORMANCE A.T.G Industries Inc. certifies that all items in this shipment conform to the requirements. Date: <u>3/12/18</u> Certified Signature: <u>[Signature]</u> Receiver Signature: _____ A.T.G Industries Inc. is AS9100 Registered and Nadcap Chemical Processing Accredited. Note: This Packing Slip may contain parts that have been PLATED. Items that are plated may be subject to natural tarnishing and it is suggested that they be inspected within 24 hours of receipt.			

Made in Canada.

